

split

Work Order ID 100541 - 2

\*100541\*

Page 1

Item ID: D2573

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 4/25/13

Start Qty: 12.00

Required Date: 5/03/13

Req'd Qty: 12.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: *MLJ*

Date: *130421* Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject  
Qty Qty Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D2573

F

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *100541*

Double check by: *[Signature]*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

*JFC 201306-20*

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

*OK 13/06/22*

*7*

*JFC 201306-20*

# Work Order ID 100541

April-22-13 1:44:11 PM

\*100541\*

Page 2

Item ID: D2573

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop \*NS2\*

Start Date: 4/25/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

OK 13/06/22

7

φ

JFC 2013-06-20

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

OK 13-6-24

7

φ

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

7



13-06-24

# Work Order ID 100541

April-22-13 1:44:11 PM

\*100541\*

Page 3

Item ID: D2573

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop \*NS2\*

Start Date: 4/25/13

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/03/13

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

\*150\*

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00  
3200F  
11:30

0.00

7x M-F 13/06/27

160

QC3- Inspect Part Finish

0.00

\*160\*

QC

Memo

0.00

Quality Control

7 x d M 13/06/27

170

Identify as per dwg & Stock Location: ST441

0.00

\*170\*

Packaging

Memo

0.00

Packaging

7x M-F 13-06-27

**Work Order ID 100541**

April-22-13 1:44:11 PM

**\*100541\***

Page 4

Item ID: D2573

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, Aft Out 205

Stop **\*NS2\***

Start Date: 4/25/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 1306-20

M/13-06-28





# Picklist Print

April-22-13 1:44:11 PM

Page 1

Work Order ID: 100541

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 4/25/13

Required Date: 5/03/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Saddle Billet

Manufactured

No

100

Each

37.0000

1 + 12 <sup>12</sup> 13-06-01

Location

Loc Qty

Loc Code

MAT041

36

85432

1

88516

4

89349

3

92730

20

98465

8

MAT042

1

85432

1

99174

① OFC 2013-06-20

8 (2)

4 (1)





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 100541
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. F		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

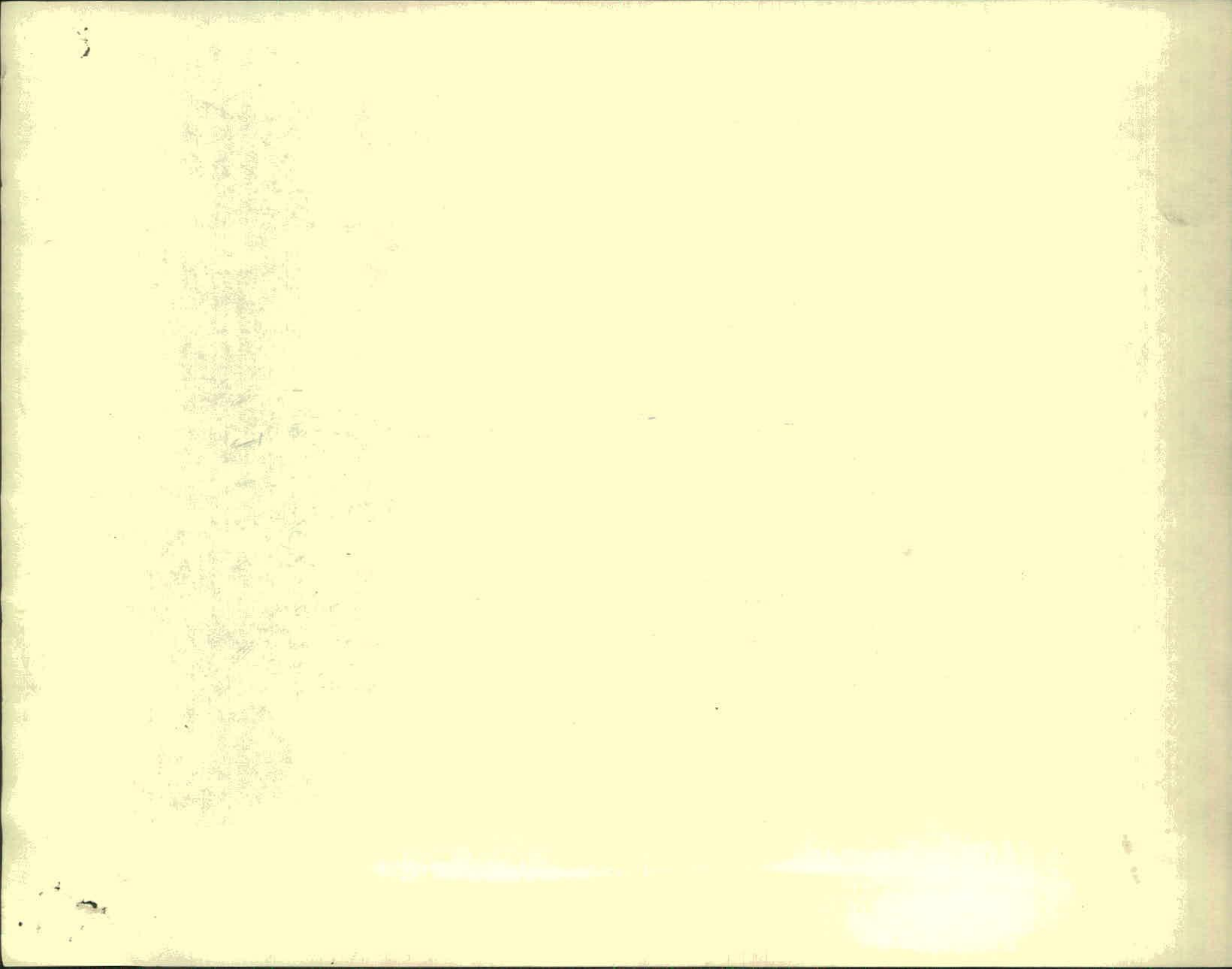
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#1	#2	#3	#4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.748	1.750	1.750	1.750		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.748	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.001	8.001	8.001		
F	0.490	0.510		0.503	.501	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		0.4975	0.501	0.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.568	0.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.122		
P	0.115	0.135		.125	0.126	0.127	.127		
Q	0.115	0.135		.132	0.132	0.132	.135		
R	0.240	0.260		.250	0.255	0.257	.257		
S	0.115	0.135		.125	0.128	0.128	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.241	0.241	.239		
W	0.115	0.135		0.130	0.132	0.132	.133		
X	0.308	0.313		0.311	.310	.309	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		0.628	.628	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		0.257	.248	.247	.248		
AE	1.500	1.520		1.513	1.513	1.514	1.513		
AF	0.115	0.135		0.127	0.127	0.127	.129		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		0.250	0.252	0.252	.249		
AI	2.000	2.020		2.003	2.0005	2.001	2.0024		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: JFC	Audited by: [Signature]
Date: 13-06-03 2013-06-20 13/06/22	Date: 15-6-24

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 100841
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. F	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	4	By	Date
A	0.438	0.443		.438	.438	.438			
B	1.745	1.755		1.750	1.750	1.750			
C	3.495	3.505		3.500	3.500	3.500			
D	1.745	1.755		1.750	1.750	1.750			
E	7.990	8.010		8.001	8.001	8.001			
F	0.490	0.510		.500	.500	.500			
G	0.257	0.262		.258	.258	.258			
H	0.375	0.380		.376	.376	.376			
I	0.490	0.510		.502	.502	.502			
J	1.174	1.184		1.179	1.179	1.179			
K	0.558	0.578		.570	.570	.570			
L	1.174	1.184		1.179	1.179	1.179			
M	1.365	1.375		1.370	1.370	1.370			
N	2.495	2.505		2.500	2.500	2.500			
O	4.119	4.129		4.123	4.123	4.123			
P	0.115	0.135		.127	.126	.127			
Q	0.115	0.135		.135	.135	.135			
R	0.240	0.260		.252	.251	.252			
S	0.115	0.135		.129	.129	.130			
T	0.178	0.198		.188	.188	.188			
U	3.210	3.250		3.230	3.230	3.230			
V	0.230	0.250		.240	.238	.239			
W	0.115	0.135		.132	.131	.131			
X	0.308	0.313		.310	.310	.310			
Y	0.760	0.765		.760	.760	.760			
Z	0.352	0.372		.364	.364	.364			
AA	0.470	0.530		.500	.500	.500			
AB	0.615	0.635		.630	.628	.630			
AC	0.053	0.073		.063	.063	.063			
AD	0.240	0.260		.249	.247	.248			
AE	1.500	1.520		1.513	1.513	1.513			
AF	0.115	0.135		.130	.130	.130			
AG	0.240	0.280		.275	.275	.275			
AH	0.240	0.260		.250	.250	.249			
AI	2.000	2.020		2.003	2.002	2.003			
AJ	0.023	0.043		.033	.033	.033			
Accept/Reject									

Measured by: <i>CMK</i>
Date: 13/06/22

Audited by: <i>SL</i>
Date: 17-8-24

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	







